INSTRUCTIONS

CURRENT INFORMATION LETTER

CRANKSHAFTS

EXPLANATION:

This instruction covers an alternate method for determining crankshaft alignment and main bearing journal concentricity if a surface plate is not available.

Thoroughly clean the crankshaft to be checked using the procedure given in present crankshaft instructions. Only a clean, undamaged main frame and new main bearing shells may be used in this method of determining crankshaft alignment.

PROCEDURE:

1. Position a clean, undamaged main frame in an inverted level position and carefully secure it to prevent it from moving.

2. Check the main bearing saddle bores for alignment. Using a straight edge or mandrel, placed in the bore and long enough to go across four saddles at a time, measure the vertical step (if any) between adjacent bores. The vertical step between adjacent bores should not exceed .002 inch.

3. Install new bearing shells in all positions, except the one where the journal is to be checked, and lightly oil them with clean engine lube oil.

4. Position the clean crankshaft on the bearing shells and see if it rotates freely. Difficulty at this point may indicate immediately that the shaft is badly bent.

5. At the unsupported journal, set up a dial indicator to read on top of the journal. Rotate the shaft slowly and read the indicator. Take 4 readings 90° apart and about 1 inch from the fillet, on each side of the journal and record.

6. Remove the bearing shell from under the next journal to be checked and apply it to the journal previously measured. Repeat step (5).

7. Repeat steps (5) and (6) until all journals have been checked. If all readings are within .002 inch TIR the shaft alignment and the concentricity of each main journal may be considered satisfactory.

These instructions do not purport to cover all details or variations in equipment nor to provide for every possible contingency to be met in connection with installation, operation or maintenance. Should further information be desired or should particular problems arise which are not covered sufficiently for the purchaser's purposes, the matter should be referred to the General Electric Company.

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